

Work Order ID 144891***144891***

Page 1

Tuesday, April 26, 2016 3:51:28 PM

Item ID: D350-591-121

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 5/10/2016 Start Qty: 2.00

Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 16/04/26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2351-041

Rev E

IIN-D350-591

H

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

MAY 12 2016

MAY 24 2016

110

Large Fab

0.00

110

Large Fab

Memo

0.78

Large Fab

1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

3-Deburr

16-5-3

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.32

120

CNC Bend 1

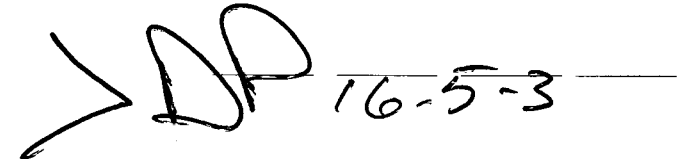
CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

0.26

Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041.

DAS
18
9-89

122

QCS- Inspect part completeness to step on W/O

0.00

122

QC

Quality Control

Memo

0.04



126

0.00

126

Large Fab

Large Fab

Memo

0.00

BUFF AND REMOVE BENDING MARKS WITHIN .005", if deeper see engineer



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Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.04							
Quality Control									
140		0.00							
140	Large Fab								
Large Fab	Memo	0.66							
Large Fab	1-Bevel Fwd and Aft end for welding								
	2-Weld Aft End Bracket per QSI004 & Dwg D2351 using Welding Jig DT8033								
	A/RAluminum Rod <u>M134442</u>								
	3-Do not Grind Flush								
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
150									
QC	Memo	0.00							
Quality Control									

DAS
03
9-89

(2)

DP 16-5-5

2 16-05-05

DAS
9
9-89

144891

Tuesday, April 26, 2016 3:51:28 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 5/10/2016 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 5/20/2016 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop ***NR2***

[illegible]

Work Order ID 144891

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Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

240

Chemical Conversion Coat per QSI005 4.1

0.00

240

HandFinish

Memo

0.10

Hand Finishing

2 16-05-18 34 9.89

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

250

Powdercoat

Memo

0.36

Powder Coating

START TIME: 8:50OVEN TEMPERATURE: 320FINISH TIME: 9:202 16-05-18 34 9.89

260

Wing Walk as per dwg QSI005 4.4 Batch _____

0.00

260

HandFinish

Memo

0.40

Hand Finishing

x264 16-05-18

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Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	QC3- Inspect Part Finish	0.00							
270									
QC	Memo	0.02							
Quality Control									
280	Pick Kit	0.00							
280									
Packaging	Memo	0.02							
Packaging									
290	QC4- 100% Inspect kits for completeness	0.00							
290									
QC	Memo	0.06							
Quality Control									

38
9-89

MAY 24 2016

DAS
27
9-89DAS
27
9-89

MAY 12 2016

2X

DAS
28
9-89

MAY 24 2016

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Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	Packaging	0.00							
300									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-591-121 Location: FG039								
	X1 Sold								
	X1 B39								
310	QC21- Final Inspection - Work Order Release	0.00							
310									
QC	Memo	0.20							
Quality Control									

27
27
9-59
MAY 24 2016

MAY 24 2016

MAY 24 2016

Picklist Print

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Work Order ID: 144891

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Parent Item: D350-591-121

D350-591-121

Parent Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 5/10/2016

Required Date: 5/20/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:E02.10.21Re-format; Incorporated D2351-041 IPPKJ/RF
IPP rev. F 06.02.23 added grinding EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2244-116		Manufactured	No			110	Each	70.0000	0.5				
-----------	--	--------------	----	--	--	-----	------	---------	-----	--	--	--	--

D2244-116

STEP EXTRUSION

**

16-5-3

Location

Loc Qty

Loc Code

HALL

70

117818

70

WA003

-0.0000368

D2850-1

Manufactured No

140

Each

2.0000

1

D2850-1

End Bracket

**

16-5-3

Location

Loc Qty

Loc Code

WA003

2

122210

2

D2582

Manufactured No

190

Each

6.0000

1

D2582

Hi-Skid Step Leg Ass'y

**

16-5-11

Location

Loc Qty

Loc Code

WA003

6

138942

6

2

Picklist Print

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Page 2

Work Order ID: 144891

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Parent Item: D350-591-121

D350-591-121

Parent Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 5/10/2016

Required Date: 5/20/2016

Start Qty: 2.00

Required Qty: 2.00

MS20600-AD4W3

Purchased

No

190

Each

398.0000

16

32

MS20600-AD4W3

Cherry Rivets

**

DP 16-5-11

Acceptable to use AD4W4

DP 16/5/11

Location

Loc Qty

Loc Code

GA

160

m129795

160

ST308

154

m133316

24

m134162

130

WA003

84

m130018

84

(2)

D2673-34

Manufactured

No

210

Each

28.0000

1

D2673-34

End Plate

**

DP 16-5-11

Location

Loc Qty

Loc Code

WA003

28

139627

28

(2)

AN4-16A

Purchased

No

290

Each

208.0000

2

4

AN4-16A

Bolt

**

DAS 0 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

FG

5

121541

5

ST343

203

M134509

80

M134606

123

2

DAS 28 9-89

** MS20600-AD4W4*

133694

30

16-5-11

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Parent Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 5/10/2016

Required Date: 5/20/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

290

Each

3,102.000

6

12

DAS

6

9-89

NAS1149D0463.J

WASHER

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

328

M132035

21

M134508

307

ST260a

1600

M134508

600

M134634

1000

ST263

186

M134039

29

M134573

157

ST269

988

M132317

100

M132677

888

12

DAS

6

9-89

D2230-1

Manufactured

No

290

Each

120.0000

1

2

DAS

27

9-89

D2230-1

Mounting Lug

Location

Loc Qty

Loc Code

FG

4

84136

4

ST521

26

115306

1

138049

25

ST525A

90

140536

70

141691

20

2

DAS
28
9-89

Picklist Print

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Work Order ID: 144891

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D350-591-121

Parent Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 5/10/2016

Required Date: 5/20/2016

Start Qty: 2.00

Required Qty: 2.00

AN3-37A

Purchased

No

290

Each

75.0000

2

4

AN3-37A

Bolt

DAS
28
9-89
DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

119086

10

ST347

65

m133694

15

m134180

50

DAS
28
9-89

MS21042L3

Purchased

No

290

Each

2,081.000

2

4

MS21042L3

Nut

DAS
28
9-89
DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

761

m133790

3

m134360

758

ST303

1220

m134039

12

m134360

608

m134634

600

DAS
28
9-89

MAY 12 2016

Tuesday, April 26, 2016 3:51:37 PM

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Picklist Print

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Work Order ID: 144891

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Parent Item: D350-591-121

D350-591-121

Parent Item Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible

Start Date: 5/10/2016

Required Date: 5/20/2016

Start Qty: 2.00

Required Qty: 2.00

AN4-13A

Purchased

No

290

Each

482.0000

3

6

DAS

8

9-89

DAS

27

9-89

AN4-13A

Bolt

**

DAS
28
9-89

Location

Loc Qty

Loc Code

FG 20

122808 20

GA 36

m134167 36

over003 300

m134634 300

ST344 126

m134260 9

m134497 117

MS21042L4

Purchased

No

290

Each

1,594.000

3

6

DAS

8

9-89

DAS

27

9-89

MS21042L4

Locknut

**

DAS
28
9-89

Location

Loc Qty

Loc Code

GA 283

m133769 283

ST303 1214

m134055 1

m134509 213

m134606 1000

ST305 97

m130922 97

MAY 12 2016

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Start Date: 5/10/2016

Required Date: 5/20/2016

Start Qty: 2.00

Required Qty: 2.00

D2230-3

Manufactured No

290

Each

101.0000

1 2

D2230-3

Mounting Lug

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

8

109344

4

89045

4

ST521

93

141406

93

D2732-030

Manufactured No

290

Each

15.0000

2 4

D2732-030

Rubber Cushion - 3"

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

10

135594

10

ST410

5

144013

5

cut (2) at 3.00"

NAS1149D0363J

Purchased No

290

Each

1,510.000

4 8

NAS1149D0363.J

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

518

m134055

518

ST263

992

m134370

19

m134606

973

DAS
6
9-89

DAS
27
9-89

MAY 12 2016

Tuesday, April 26, 2016 3:51:37 PM

Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2351	REV. E SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SCALE NTS
A	95.02.15	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	98.12.17	CHANGED TO BEND, D2850 REPLACES D2357 & D2358, INCORP. DEO 9084	
E	05.11.14	UPDATE FINISHING NOTE	

D2351 HIGH FLOAT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY -041	QTY -042
D2351-041	High Float Step Assembly (LH)	X	
D2351-042	High Float Step Assembly (RH)		X
D2244-55.4	STEP EXTRUSION*	1	1
D2582	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2850-1	END BRACKET	1	
D2850-2	END BRACKET		1
MS20600AD4W3	RIVETS	16	16

*cut per drawing

RELEASED
05.11.28 [Signature]

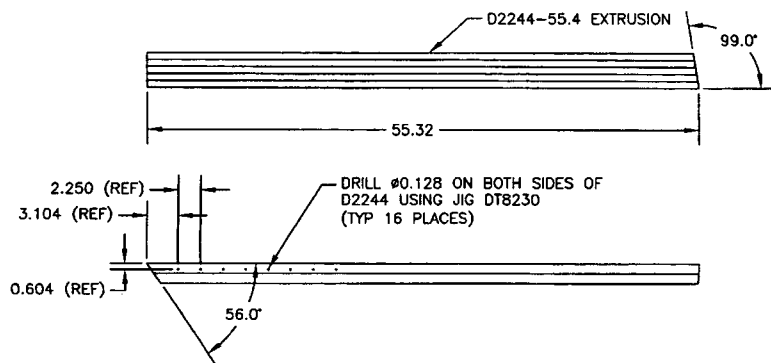
PH
ECN 1105
UNDER REVIEW
07.11.29 [Signature]
P42102# 263

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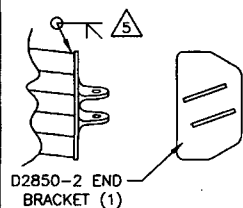
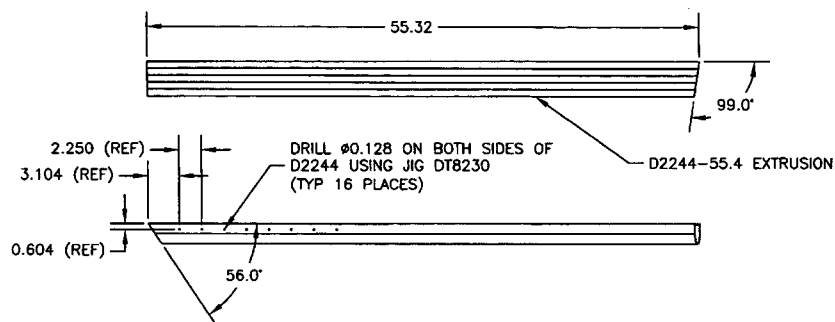
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3/0 144891
2m 16/04/26

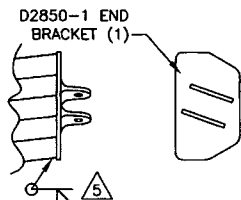
D2351-2 CUTTING/DRILLING DETAIL
RIGHT STEP



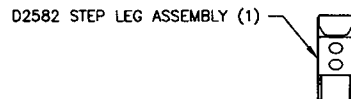
D2351-1 CUTTING/DRILLING DETAIL
LEFT STEP



DETAIL A
SCALE: 1:4



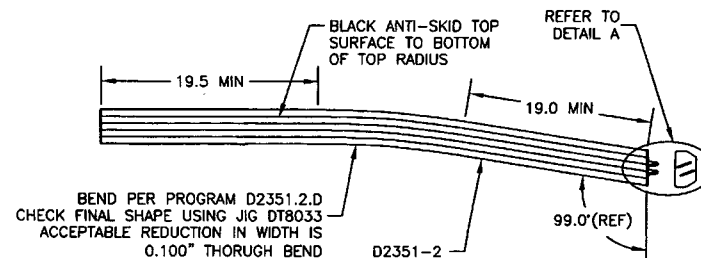
DETAIL B
SCALE: 1:4



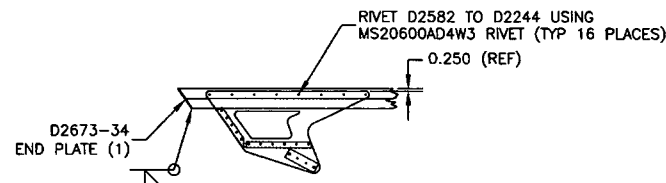
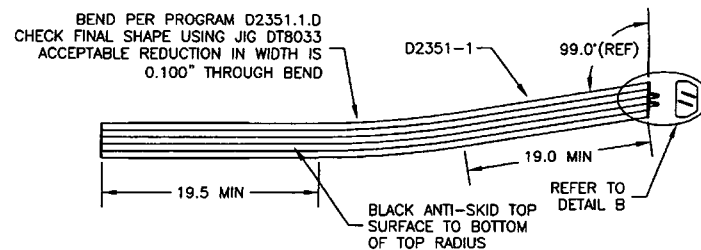
GENERAL NOTES

- 1) WELD PER DART QSI 004
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- △ CHAMFER D2244 EXTRUSION 0.075"x45° BEFORE WELDING D2850-1 OR D2850-2 IN PLACE. DO NOT GRIND FLUSH.

D2351-042 BENDING/ASSEMBLY DETAIL
RIGHT STEP



D2351-041 BENDING/ASSEMBLY DETAIL
LEFT STEP



RELEASED
05.11.28

UNDER REVIEW

ECV 1105

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		CHECKED	APPROVED	D2351	SHEET 2 OF 2
		DATE		TITLE	SCALE
		05.11.14		HIGH FLOAT STEP ASSEMBLY	1:12

5.0 PARTS LIST

DAS
28
9-89

Qty -117A	Qty -119	Qty -133	Part Number	Description
X			D350-591-117A	<i>Hel-Access-Step</i> ™, Pre-Flight Step
	X		D350-591-119	<i>Hel-Access-Step</i> ™, Long Step – Low Skid
		X	D350-591-133	<i>Hel-Access-Step</i> ™, Aft Maintenance Step
	1		D2355	STEP ASSEMBLY (LOW-LONG)
		1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
2	2		D2171	CLAMP
2	2		D2182B035	CUSHION
		4	D2230-1	MOUNTING LUG
		4	D2230-3	MOUNTING LUG
4	4		D2274	RADIUS BLOCK
1			D2362-041	SUPPORT BRACKET
	1		D2362-3	SUPPORT BRACKET
		1	D2945	MOUNTING PLATE
1	1		D3595-200-300	CUSHION
		8	D2732-030	CUSHION
	2		AN3-37A	BOLT
		2	AN4-7A	BOLT
		4	AN4-11A	BOLT
		8	AN4-16A	BOLT
	4		AN4-21A	BOLT
4	1		AN4-22A	BOLT
	4		NAS1149D0363J	WASHER (AN960JD10)
4	6	14	NAS1149D0463J	WASHER (AN960JD416)
	2		MS21042L3	NUT
4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Hel-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Hel-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Hel-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Hel-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
2	2	2	2	D2732-030	CUSHION
2	2	2	2	AN3-37A	BOLT
1	1	1	1	AN4-13A	BOLT
2	2	2	2	AN4-16A	BOLT
4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT